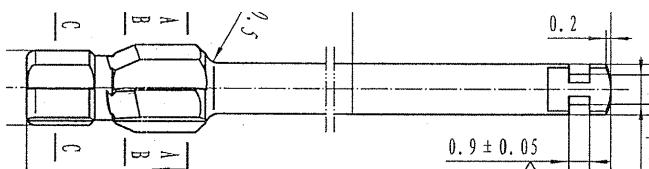


Dental Countersink Ø3.5 Z4

A26-560

The dental countersink is ground in one setup clamped on the 2.35 shank and additionally supported in a V-shaped steadyrest. For automatic loading the steadyrest can be automatic. The 2 radius-shaped clearances are ground based on a DXF-file. Grinding time for O.D. is low due to usage of fullform wheel. Preorientation of the blank is given through loading without probing.



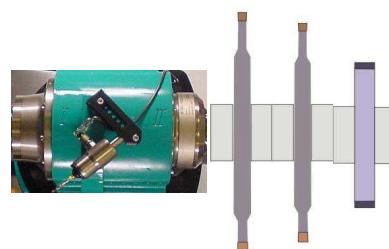
1. Cycletime for Production

Workpiece:	Ø3.5/4.1 mm, Z 4, Length 8 mm, Step 50°			
Material HSS				
Operations	O.D.2	O.D.1	Step 1	Flute
Feed [mm/Min]	200	300	300	150
Power [kW]	1	1	1	1
Cutting speed [m/s]	32	32	32	32
Used wheels	1	1	2	3
Grinding time [s]	15	11	10	39
Total cycle time	1 Min 15			

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	14A1 Ø175 B91
2	14V1 Ø150 B91 V65°
3	1A1 Ø75 B76



1 2 3

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG
 Control: Fanuc 31iA5
 Accessories: Steadyrest at shank and tip
 Responsible engineer: PSI. 26.4.12

Coolant: Synthetic Oil, pressure 6 bar
 Software: Quinto 5

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